

Work Order ID 70794

Wednesday, June 15, 2011 10:49:29 AM



ASAP

Page 1

Item ID: D412-785-001-403

Accept



Setup Start



Revision ID:

Stop



Item Name: Faceplate

Start Date: 6/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

MK

Date:

11-06-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D412-785-001-10

B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: B

Prog Rev: 2

2-Deburr if necessary

B11-6-15

②

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70794

Wednesday, June 15, 2011 10:49:30 AM



Page 2

Item ID: D412-785-001-403

Accept



Setup Start



Revision ID:

Stop



Item Name: Faceplate

Start Date: 6/15/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8/16/16

(72)

Quality Control

140

NC BRAKE

0.00



Brake NC

Memo

0.00

8/16/16

(10) R10 →

Brake NC

Bend as per Dwg

BE Check per Dwg

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/16/16

(11)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-785-001-403 PAR #: 1/P Fault Category: RC: Small Tab NCR: Yes No DQA: 1 Date: 11.06.27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 1 Date: 11/06/27

NCR: <u>70794</u>		WORK ORDER NON-CONFORMANCE (NCR) <u>58.78</u>						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11.06.16</u>	<u>140</u>	ONE PART OUT OF TOLERANCE. <u>Other?</u> RC: PROCESS. NO ADEQUATE	<u>11.06.16</u> <u>G10AC</u> <u>4.2.6</u>	ONLY ONE PART REQ'D. SCRAP, NO REDUCE.	<u>S</u> <u>11.06.16</u>	<u>S</u> <u>11.06.16</u>	<u>11.06.16</u>	<u>11.06.16</u>
		TOOLING. NO TOOLING WILL BE MADE. CUSTOM PART MIGHT NOT BE MANUFACTURED AGAIN.						

NOTE: Date & initial all entries

Work Order ID 70794

Wednesday, June 15, 2011 10:49:30 AM

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Item ID: D412-785-001-403

Accept

Setup Start

Revision ID:

Stop

Item Name: Faceplate

Start Date: 6/15/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 6/17/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BR 11-6-17.

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

IX of MP 11/06/17

180

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

11/6/00 SP (D)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70794

Wednesday, June 15, 2011 10:49:30 AM

Page 4

Item ID: D412-785-001-403

Accept

Revision ID:

Item Name: Faceplate

Start Date: 6/15/2011 Start Qty: 1.00

Required Date: 6/17/2011 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/06/2011
ME
11-06-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, June 15, 2011 10:49:25 AM

Page 1

Work Order ID: 70794

Parent Item: D412-785-001-403

Parent Item Name: Faceplate





Start Date: 6/15/2011

Required Date: 6/17/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA 11.06.15 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	8.5000	0.098	0.103158			
													
6061-T6 Sheet 0.032"													

FB 11-6-15

Location

Loc Qty

Loc Code

MAT021

8.5

110063

3

16954

5.5

110063

⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 76794
Description: FINE PLATE		Part Number: D412785001-403
Inspection Dwg: D412-785-001-403	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X

First Article

X

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .1098	+ .004 - .001	.1100	✓		V B02	
Ø .1189	+ .005 - .001	.1193	✓		V	
Ø .750	+ .005 - .001	.752	✓		V	
Ø 2.25	+ .012 - .001	2.252	✓		V	
4.92	± .30	4.930	✓		V	
4.18	± .030	REMA			V	
4.06	± .30	4.047	✓		V	
.86	± .030	.866	✓		V	
.344	± .30	.344	✓		V	
.688	± .030	.688	✓		V	
1.83	± .030	1.831	✓		V	
.312	± .030	.311	✓		V	
.656	± .030	.656	✓		V	
.36	± .030	.362	✓		V	
2.75	± .030	2.749	✓		V	
2.88	± .030	2.870	✓		V	
.31	± .030	.311	✓		V	
1.12	± .030	1.125	✓		V	
1.68	± .030	1.684	✓		V	
2.61	± .030	2.610	✓		V	
1.86	± .030	1.857	✓		V	
.45	± .030	.445	✓		V	
1.86	± .030	1.858	✓		V	
.030	± .010	.31	✓		V	

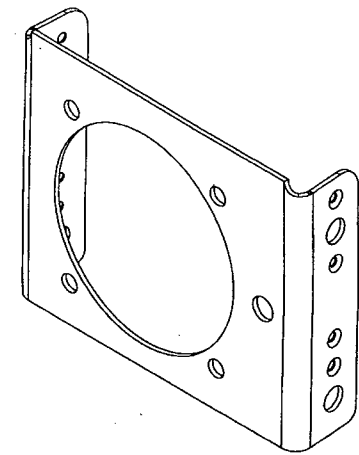
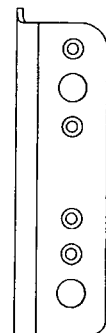
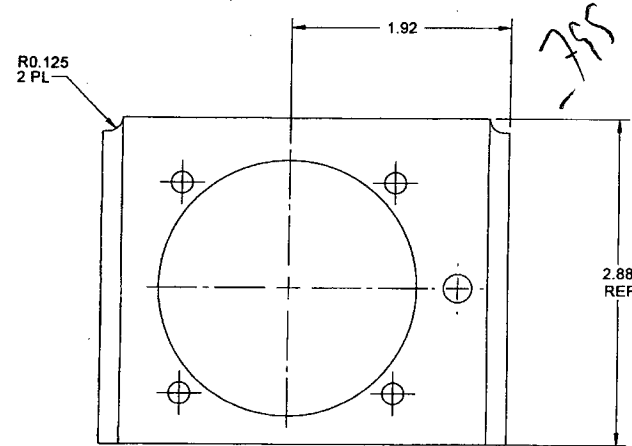
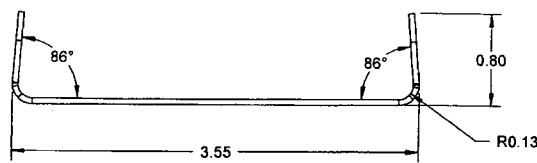
Measured by: MB
Date: 11-6-16

Audited by: [Signature]
Date: 11/6/16

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1



D412-785-001-403 FACE PLATE
MADE FROM D412-785-001-403F FLAT PATTERN

70794

RELEASED
10/8/25

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.05 lbs

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DRAWN	1	CALGARY, ALBERTA, CANADA	
CHECKED	1	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-001-101	SHEET 7 OF 10
APPROVED	1	TITLE	SCALE
DE APPR.	N/A	LOADCELL METER MOUNT	NTS
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8 7 6 5 4 3 2 1

D412-785-001-403F FLAT PATTERN

RELEASED
10/12/25

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN	AS	CALGARY, ALBERTA, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-001-101	SHEET 8 OF 10
APPROVED	AS	TITLE	SCALE
DE APPR.	N/A	LOADCELL METER MOUNT	NTS
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